

Work Order ID 53697

November 12, 2009 2:29:08 PM



Page 1

Item ID: D3454-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bushing

Start Date: 11/12/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3454

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

SA 09/11/13

23 *0*

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA572 & DWG D3454, 1 FOLIO
REV: *B* □ DWG REV: *B* □ 2-DEBURR AS REQUIRED

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

SA 09/11/13

23 *0*

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

ant 09/11/13

23 *0*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53697

November 12, 2009 2:29:09 PM

Page 2

Item ID: D3454-5

Accept

Revision ID: B

Item Name: Bushing




Start Date: 11/12/09 Start Qty: 20.00

Required Date: 11/20/09 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00				23	✓		
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140  QC	QC5- Inspect part completeness to step on W/O	0.00				✓	✓		
QC	Memo	0.00							
Quality Control									
150  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53697

November 12, 2009 2:29:09 PM

Page 3

Item ID: D3454-5

Accept

Revision ID: B

Item Name: Bushing

Start Date: 11/12/09 Start Qty: 20.00

Required Date: 11/20/09 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/16
ME 09-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 12, 2009 2:29:08 PM

Page 1

Work Order ID: 53697



Parent Item: D3454-5RevB



Parent Item Name: Bushing

Start Date: 11/12/09

Required Date: 11/20/09

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	108.9000	0.7895			



303 Round Bar 0.750

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	108.9	
107077	0	
113134	108.9	

~~821~~ 21 NOV 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53697
Description: Bushing		Part Number:	D3454-5
Inspection Dwg: D3454 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

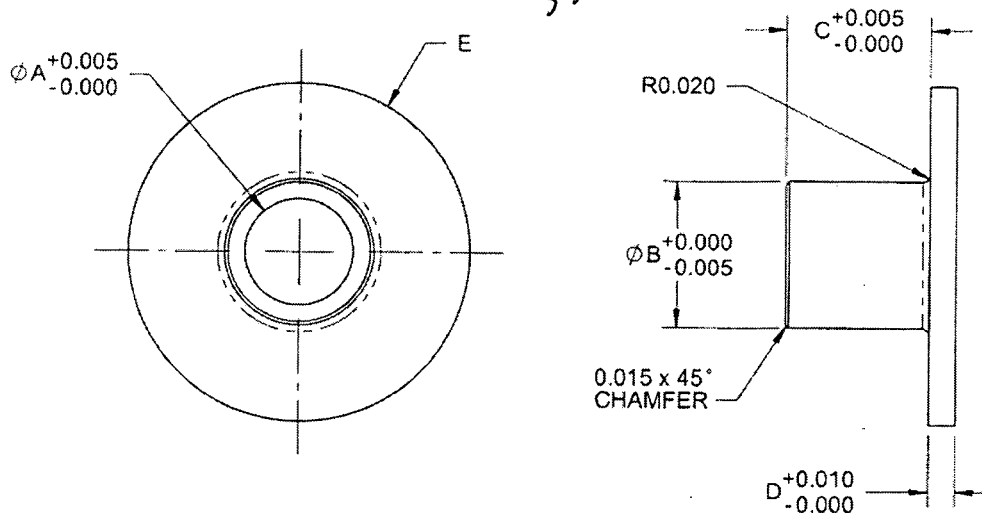
[illegible]

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	07.01.17	0.60 dimension removed	KJ/JLM	
C	07.09.06	0.060 dimension added	KJ/JLM	
D	09.05.04	Tolerance for 0.060 revised	KJ/DD	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3454	REV. B SHEET 1 OF 1
DATE 05.12.05		TITLE BUSHING	SCALE 2:1
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

RELEASED

05.12.05 *[Signature]**WLO 3647***D3454-X**1) SPECIFICATION: **D3454-X BUSHING**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75

**NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.